

Date: Tuesday, 5/23/2006 8:12:51 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 27163		
Estimate Number	: 10101		
P.O. Number	: N/A	Part Number	: D2011101
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: D2011 REV. F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: F
Previous Run	: 24967	Material	: N/A
Written By	: See Comment below	Due Date	: 6/2/2006
Checked & Approved By	: AF 06.05.23	Qty:	50 Um: Each
Comment	: Est: J 04.09.15 Added Steps 5-7 Est: K 05.12.15 chg black sikaflex for white EC	KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>1309</u> Purchase Grote Mirror P/N: 28043 Possible supplier: UAP/NAPA Material release note required
2.0	28043	MIRROR 6"
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Mirror 6"
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	D30141	Locknut
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Locknut Pick: Qty Part Number Description Batch 1 D3014-1 Lock nut <u>B25021</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-05-30	3.	Add QC G to receiving inspection permanent change	Inspected by J. W. 30			J. W. 30-09	06-05-30

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-05-30	6	I mirror broke when drilled holes	J. W. 06-05-30	Scrap + destroy	S. H. 06-05-30 06/06/09	J. W. 06-06-09	J. W. 06-06-09	J. W. 06-06-09
				HA! HA!				
				Sever gns				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA:

Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: 6" MIRROR

Job Number: 27163

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416L	Washer	M3159

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill-mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291-241 adhesive per hole.

Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291-241	7/11/2006
		Expiry date	11/09/00

H.T 06/06/01

50

4- Test assembly to 50lbs pull test after 24 hours

Start: 06:06:07 Time: 1h 00

Finish: 06:06:07 Time: 2h 45

SAD 06:06:07

49

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST244

DOCUMENT CONTROL

Re 06/08 49

9.0 DC



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/09

49

Job Completion



U 06/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

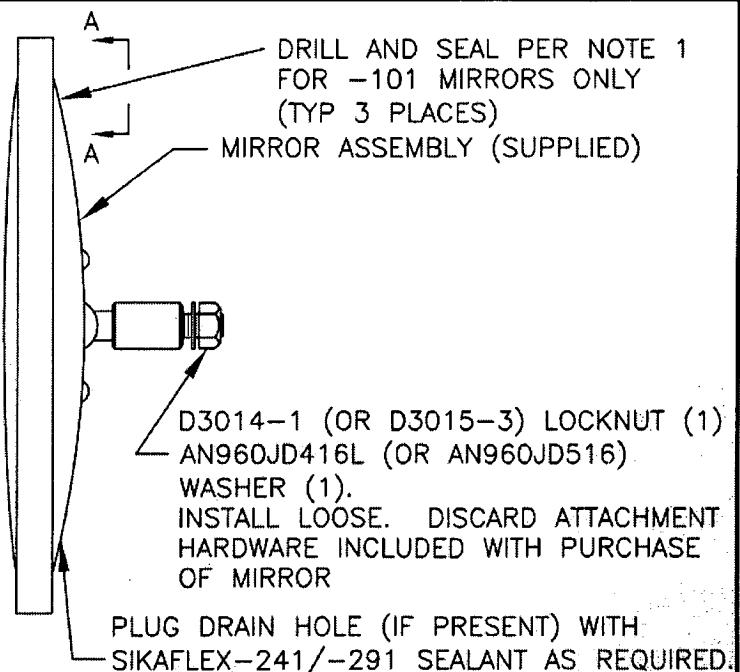
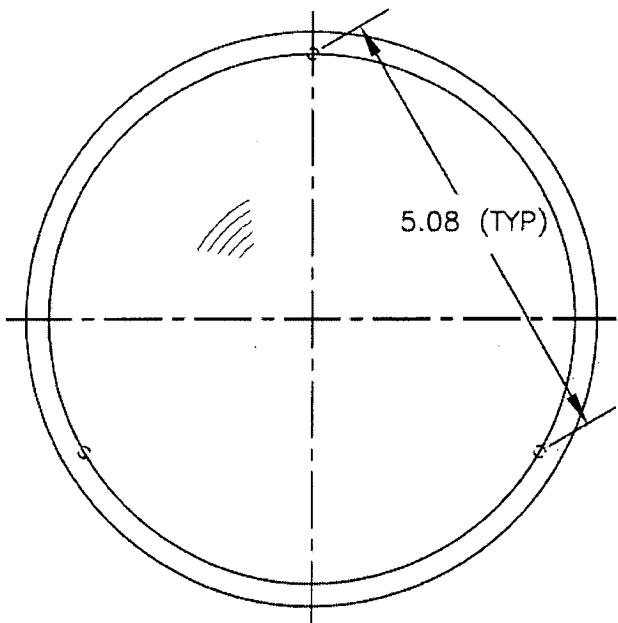
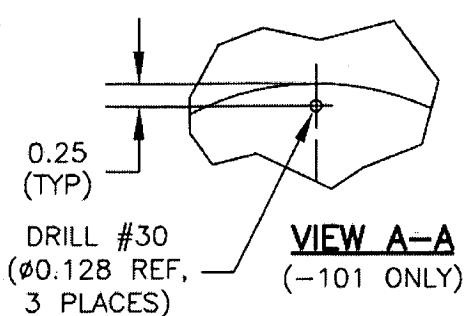
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
1		D3015-3	LOCKNUT
1		AN960JD516	WASHER

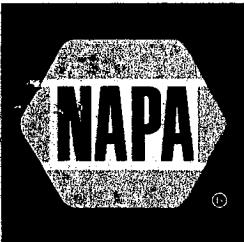
RELEASED
04.09.10
R

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27163

NOTES:

1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



AWKESBURY AUTO PARTS INC 5580GST#: 861597896RT0001
14 MAIN STREET WEST EXC#: SU 6259 EXP:03/12/31
AWKESBURY, ONT. K6A 2J2 DANGEROUS GOODS PERMIT
TEL:632-8575 FAX: 632-1539 EXPIRY DATE:
EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO		DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		5/24/06	16:46	060004074	31	120088
SR #					PURCHASE ORDER #		ATTENTION
6					1309		
AD					TAX EXEMPTION: 6122-5207		
21					TERMS: NET 30 DAYS		CHARGE SALE
					DELIVERY:		
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL	
28043L DIRECT CONNECT	GRO GROTE PURO		✓ 50.00	41.140	16.820	841.00	T150

REFUNDED BY _____

Subtotal 841.00
Tax 7% GST ONLY 58.87
Tax 0% 0.00

VERIFIED BY _____

F. Clark Gatos

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE 899.87